

17/09

6

Date: Tuesday, 9/11/2007 10:58:05 AM
User: Chantal Lavoie

Process Sheet

Customer :
Job Number : 34548
Estimate Number : 12965
P.O. Number :
This Issue : 9/11/2007 S.O. No. :
Prsht Rev. : NC
First Issue : // Type : SMALL /MED FAB
Previous Run :
Written By :
Checked & Approved By :
Comment : Est Rev:A New Issue 07-07-20 JLM Verified By:EC

Drawing Name : STIFFNER
Part Number : D36432
Drawing Number : D3643 UNDER REVIEW
Project Number : N/A
Drawing Revision : U/R
Material :
Due Date : 9/18/2007 Qty: 20 Um: Each

POSITIVE RECALL

Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 M2024T3S040 2024-T3 .040 sheet



Comment: Qty.: 0.1549 sf(s)/Unit Total: 3.0975 sf(s)

2024-T3 .040 sheet

Batch: M105225 HB 07-09-17

2.0 WATER JET FLOW WATER JET



Comment: FLOW WATER JET

1-Cut as per Dwg D3643

Dwg Rev: A HB 07-09-17

Prog Rev: A

2-Deburr if necessary HB 07-09-17

20

3.0 QC2 INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

HB 07-09-17

4.0 QC8 SECOND CHECK



Comment: SECOND CHECK

Er 07/09/17 20

counts

5.0 BRAKE NC NC BRAKE



Comment: NC BRAKE

Form as per Dwg D3643

SB 07/09/18

PRO

20
+5

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D3643-2 PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: DD Date: 07/10/16
 QA: N/C Closed: _____ Date: _____

NCR: <u>34548</u>		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
07/01/12	#6.0	2 seats serial R.C. center side m Deep Human error	07/01/12	Error and Destroy and Repair: Serial Re-percol and Re-count Sink	07/01/12 07/01/12	07/01/12	07/01/12	07/01/12

NOTE: Date & initial all entries

Date: Tuesday, 9/11/2007 10:58:05 AM
User: Chantal Lavoie

Process Sheet

Customer:

Drawing Name: STIFFNER

Job Number: 34548

Part Number: D36432

Job Number:



Seq. #:

Machine Or Operation:

Description:

6.0

SMALL FAB 1

00

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

C'sink as per Dwg D3643

mf 07-09-21
mf 07-09-18

Total
23

7.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

cauto
07-09-21

23

8.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

BR

07-09-24

23

9.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

cauto
07-09-24

23

10.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify with P/N and B/N using a permanent fine point marker then Stock

Location: _____

7/10/15 SD

ENGINEERING
APPROVAL

LE 07.10.15

11.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

07.10.16

Job Completion



POSITIVE RECALL

EFFECTIVE 07.10.11 AUTH

RELEASED

DATE 07.10.16

07.10.16

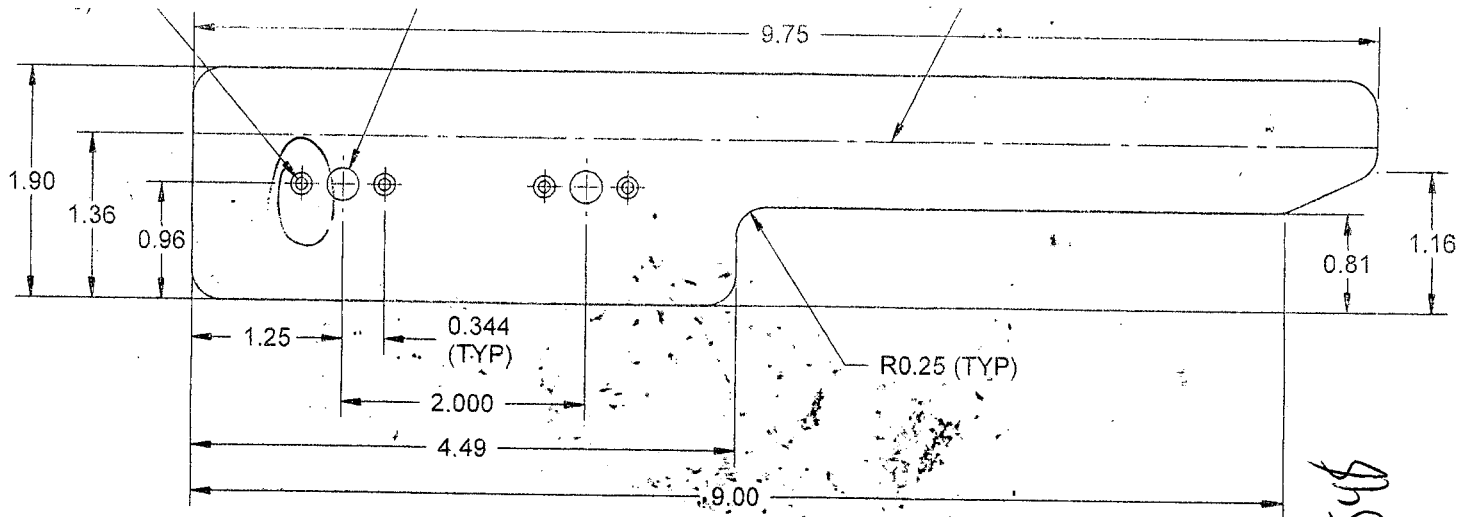
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

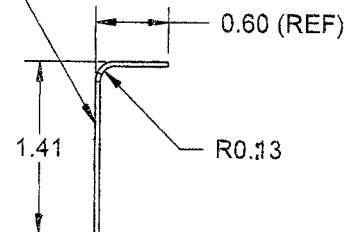
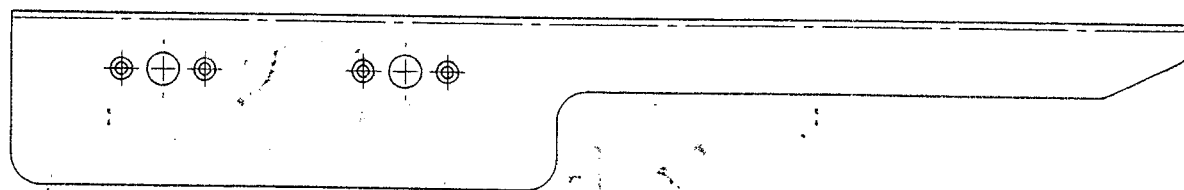
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



**D3643-1F FLAT PATTERN
(D3643-2F OPPOSITE)**

ENSURE THAT COUNTERSINKS
ARE ON THIS SIDE OF THE PART



**D3643-1 STIFFENER (REPLACES GENEVA P/N G10610-2)
D3643-2 OPPOSITE (REPLACES GENEVA P/N G10610-1)**

2024-T3 ALUMINUM SHEET 0.040 THICK PER QQ-A-250/4 OR AMS 4037
REF DART SPEC M2024T3S.040)
MICAL CONVERSION COAT PER DART QSI 005 4.1
S: PER DART QSI-018 UNLESS OTHERWISE NOTED
T S UNLESS OTHERWISE NOTED

A	NEW ISSUE; REPI
REV.	
DESIGN	DT
DRAWN	CE
CHECKED	
MFG APPR	CE
APPROVED	CE

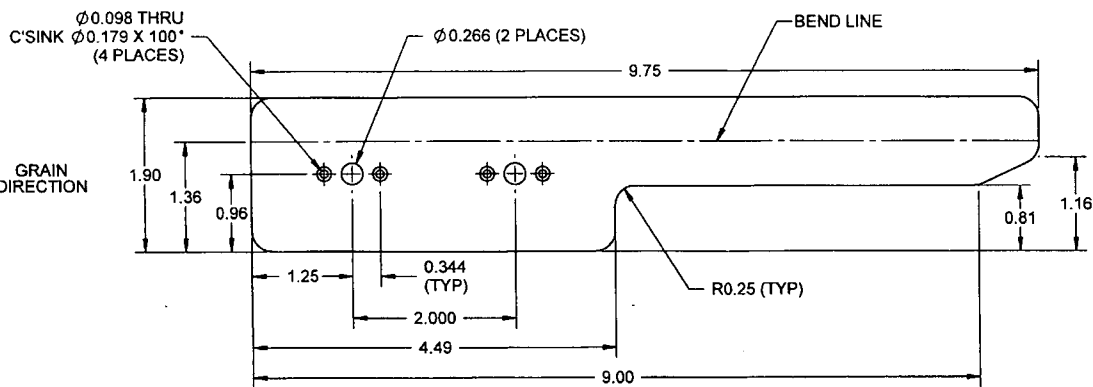
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

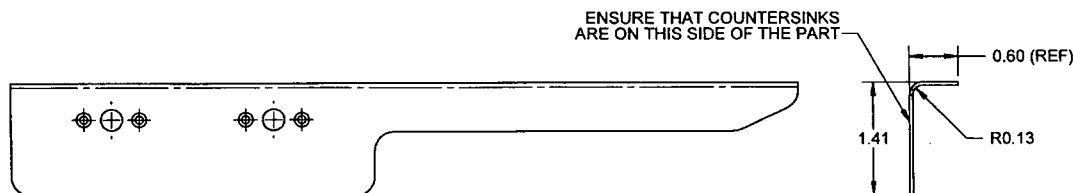
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

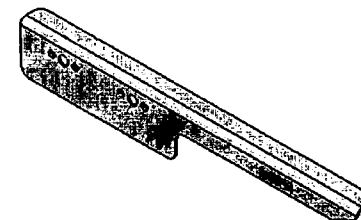


D3643-1F FLAT PATTERN
(D3643-2F OPPOSITE)

REFERENCE ONLY



D3643-1 STIFFENER (REPLACES GENEVA P/N G10610-2)
D3643-2 OPPOSITE (REPLACES GENEVA P/N G10610-1)



- NOTES:**
- 1) MATERIAL: 2024-T3 ALUMINUM SHEET 0.040 THICK PER QQ-A-250/4 OR AMS 4037 (REF DART SPEC M2024T3S.040)
 - 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3643-1/-2" USING FINE POINT PERMANENT INK MARKER
 - 7) WEIGHT: 0.06 lbs

RELEASED
07.09.07

A	NEW ISSUE; REPLACES G10610		LE	07.07.27
REV.	DESCRIPTION		BY	DATE
DESIGN	DT	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA		
DRAWN	CE			
CHECKED	B		DRAWING NO.	REV. A
MFG. APPR.	E		D3643	SHEET 1 OF 1
APPROVED	MD		TITLE	SCALE
DE APPR.	JH		STIFFENER	2:
DATE	07.07.27		COPYRIGHT © 2007 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	